

Work Order ID 57364

April 6, 2010 8:34:39 AM



Page 1

Item ID: D3370-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 06/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-4-06

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3370

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 2.500" x 4.120" long

ml 10/04/06

6 0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine D3370-3 as per Folio FA482 and Dwg D3370 Identify as D3370-3 Dwg Rev: *C*

ml 10/04/06

6 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

ml 10/04/06

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57364

April 6, 2010 8:34:39 AM



Page 2

Item ID: D3370-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Pedal Lock Cover

Start Date: 06/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 16/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				X6	0		
150 Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 11102391 Memo START TIME: 7:15AM OVEN TEMPERATURE: 7:45AM FINISH TIME: 320°F	0.00 0.00				X6	0		

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Page 3

Item ID: D3370-3

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Revision ID:

Item Name: Pedal Lock Cover

Start Date: 06/04/2010 Start Qty: 6.00

Required Date: 16/04/2010 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⑥ ϕ BK 10-4-14.

170

Identify as per dwg & Stock Location: 491

0.00



Packaging

Memo

0.00

Packaging

10-4-16 SP ϕ

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/19 ϕ

PL 10-4-14 ϕ

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 6, 2010 8:34:43 AM

Page 1

Work Order ID: 57364



Parent Item: D3370-3



Parent Item Name: Pedal Lock Cover

Start Date: 06/04/2010

Required Date: 16/04/2010

Comments: IPP B 05.05.25 Added Powder Coat KJ/JLM
IPP Rev:C 08-07-17 revC as per dwg DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No			100	f	116.0000	2.1998			



6061-T6 Bar 1.50 x 2.50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT10

116

103069

12

107387

61

→ 16716

7

16742

36

2.1998 *ml 10/04/06*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	57364
Description: Pedal Lock Cover		Part Number:	D3370-3
Inspection Dwg: D3370	Rev: 8	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.007	/			
3.344	+/-0.010	3.339	/			
0.592	+/-0.010	.590	/			
0.202	+/-0.010	.206	/			
Ø1.000	+0.005/-0.000	Ø1.002	/			
0.25	+/-0.030	.257	/			
0.283	+/-0.010					
2.000	+/-0.010	2.002	/			
0.300	+/-0.010	.299	/			
0.550	+/-0.010	.551	/			
1.50	+/-0.030	1.497	/			
Ø1.250	+0.005/-0.000	Ø1.250	/			
0.635	+/-0.010 ^{+0.010} _{-0.000}	.635	/			
Ø0.750	+0.010/-0.000	Ø.758	/			
1.673	+/-0.010	1.671	/			
0.430	+/-0.010	.429	/			
2.638	+/-0.010	2.637	/			
2.35	+/-0.030	2.355	/			
0.715 deep	+/-0.010	.715	/			
15°	+/-0.1°	15°	/			
0.19 x 45°	+/-0.030	.190 x 45°	/			
0.450	+/-0.010	.450	/			
1.450	+/-0.005	1.450	/			

Measured by:	WLF
Date:	10/04/06

Audited by:	MMF
Date:	10/04/06

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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△

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57364

10-4-06

RELEASED
08.07.11

C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.		AJS	08.07.11
B	D3385-3 WAS D3385-1		MB	05.03.22
A	NEW ISSUE		RF	04.12.15
REV.	DESCRIPTION		BY	DATE
DESIGN	MB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3370 REV. C SHEET 1 OF 4 TITLE PEDAL LOCK SCALE NTS <small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
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MFG. APPR.	<i>[Signature]</i>			
APPROVED	<i>[Signature]</i>			
DE APPR.	<i>[Signature]</i>			
DATE	08.07.11			

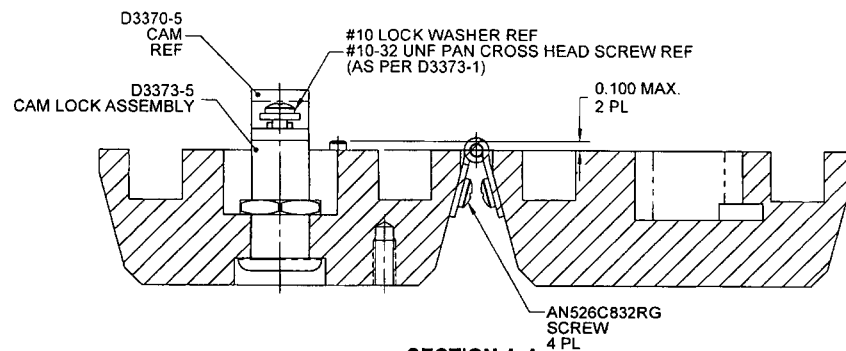
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

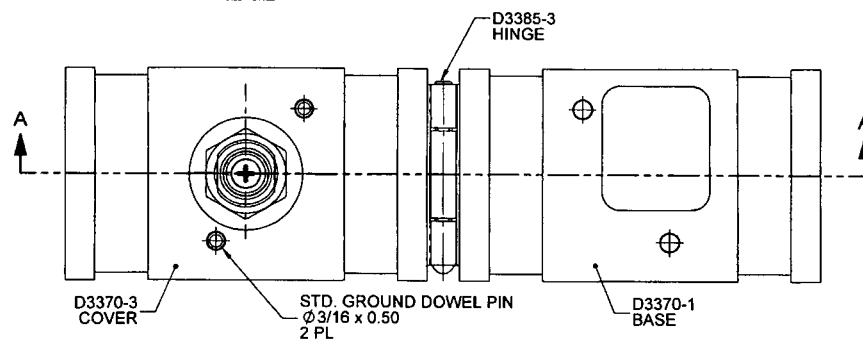
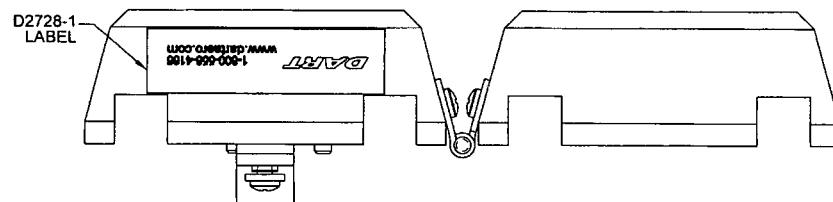
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NOTE: Date & initial all entries



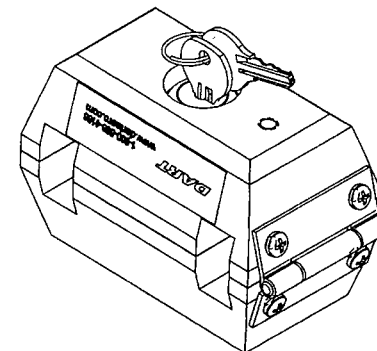
SECTION A-A



D3370-051 PEDAL LOCK ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs



w/o 57364

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08-07-11

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MFG. APPR.		D3370	SHEET 2 OF 4
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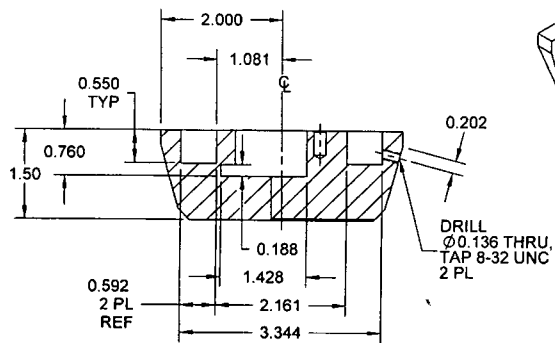
Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

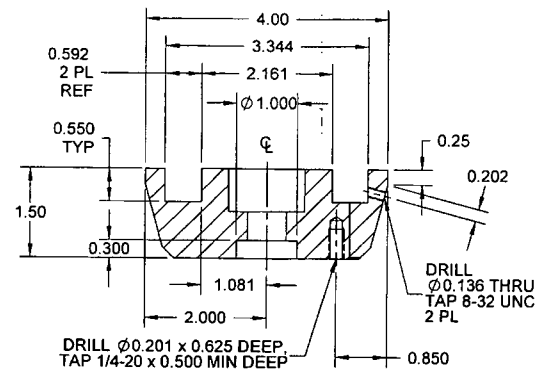
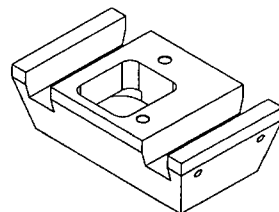
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

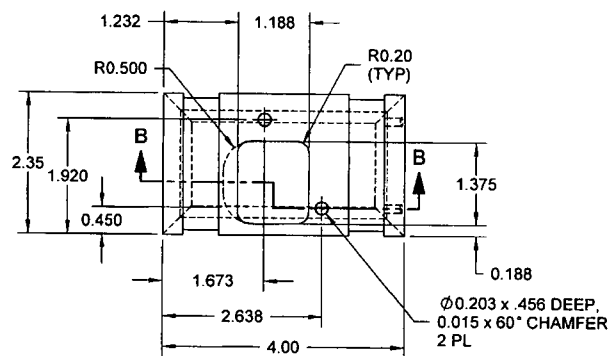
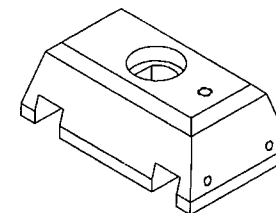
NOTE: Date & initial all entries



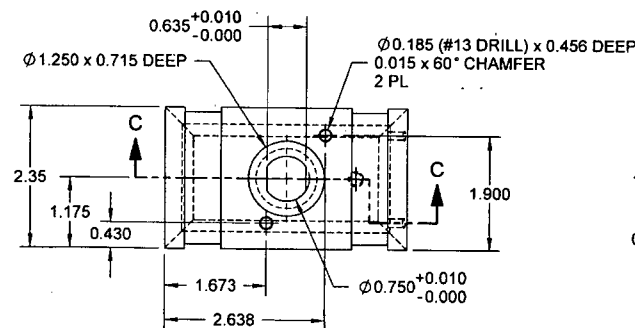
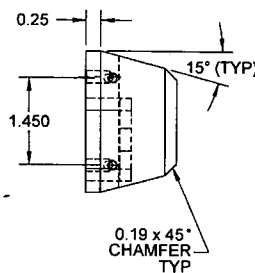
SECTION B-B



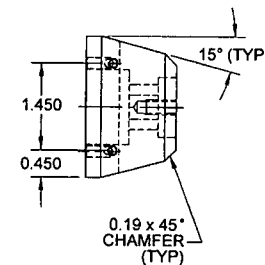
SECTION C-C



D3370-1 BASE







D3370-3 COVER



RELEASED
08-07-16

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

DESIGN	MB	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 3 OF 4
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DE APPR.		PEDAL LOCK	NTS
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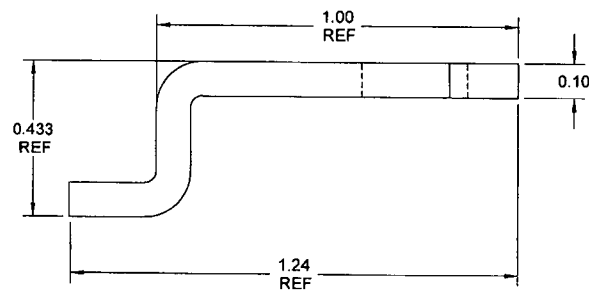
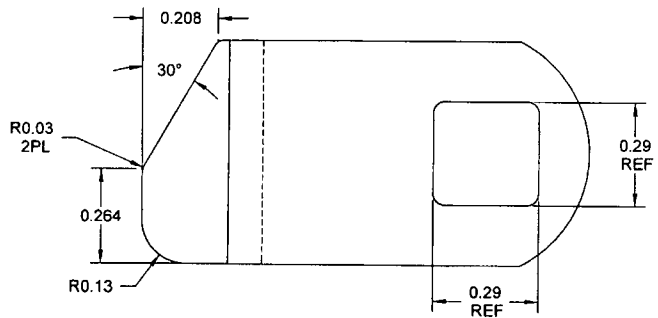
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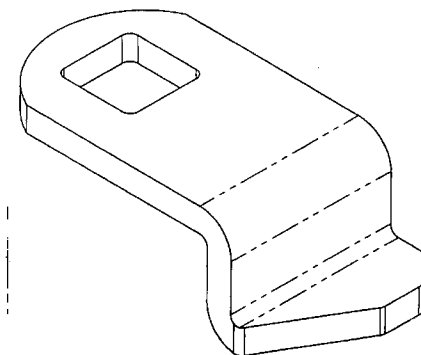
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NOTE: Date & initial all entries



D3370-5 CAM



wlo 57364

RELEASED
78014

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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